

Work Order ID 140579

Thursday, January 07, 2016 3:20:45 PM

HAI

140579

For JAN 22

Page 1

Item ID: D139-799-017 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cargo Floor Protector - Cargo Compartment
 Start Date: 1/7/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/22/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MCS Date: JAN 07 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D139-799	K

100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D139-799-017 CHG004								

DAS
28
9-89

JAN 13 2016

MW 1601-13

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAG
6
9-89

JAN 13 2016

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89

JAN 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 140579

140579

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Thursday, January 07, 2016 3:20:45 PM

Item ID: D139-799-017 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Floor Protector - Cargo Compartment
 Start Date: 1/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/22/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-017								
	Location: _____								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS JAN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 140579

140579

Parent Item: D139-799-017

D139-799-017

Parent Item Name: Cargo Floor Protector - Cargo Compartment

Start Date: 1/7/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 10.06.08 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERF BY:DD IPP Rev:C 11.09.27
PER CHG003 DD verf:EC IPP Rev:D 11.11.16 removed (1)
D4153-1 & add (1)-3 DD verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3580-1 *D3580-1* Joggle Bracket		Manufactured	No			110	Each	39.0000	2	2		DAS 6 9-89	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST043				39		2			
				136060				39					
D3628-1 *D3628-1* Washer, Cupped		Manufactured	No			110	Each	158.0000	2	2		DAS 6 9-89	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				10					
				83587				10					
				ST046				148					
				123627				148					
D4130-5 *D4130-5* Fwd Cargo Floor Protector		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	DAS 27 9-89
D4130-7 *D4130-7* Center Cargo Floor Protector		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	DAS 27 9-89
D4130-9 *D4130-9* Aft Cargo Floor Protector		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	DAS 27 9-89

JAN 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Page 2

Work Order ID: 140579

140579

Parent Item: D139-799-017

D139-799-017

Parent Item Name: Cargo Floor Protector - Cargo Compartment

Start Date: 1/7/2016

Required Date: 1/22/2016

Start Qty: 1.00

Required Qty: 1.00

D4153-1 Manufactured No

110 Each 4.0000 1 1

D4153-1

Joggle Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST197

4

108164

4

DAS
6
9-89

D4153-3 Manufactured No

110 Each 8.0000 1 1

D4153-3

Joggle Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

ST198

8

103123

4

111410

4

DAS
6
9-89

D4166-1 Manufactured No

110 Each 64.0000 2 2

D4166-1

Placard, Max Load

DAS
28
9-89

Location

Loc Qty

Loc Code

ST088

64

137500

64

DAS
6
9-89

JAN 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

Work Order ID 140579

Thursday, January 07, 2016 3:20:45 PM

140579

Page 1

Item ID: D139-799-017

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Item Name: Cargo Floor Protector - Cargo Compartment

Stop ***NS2***

Start Date: 1/7/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/22/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5 Date: JAN 07 2016

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D139-799

K

100	Document Control	0.00							
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100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D139-799-017
CHG004ML5 JAN 13 2016

110	Pick Kit	0.00							
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110

Packaging

Memo

0.00

Packaging

ML5 JAN 13 2016

120	QC4- 100% Inspect kits for completeness	0.00							
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120

QC

Memo

0.00

Quality Control



5.0 PARTS LIST

Qty -011	Qty -012	Qty -015	Qty -017	Qty -019	Qty -112	Qty -211	Qty -212	Qty -213	Part Number	Description
X									D139-799-011	MAINTENANCE STEP KIT, LH
	X								D139-799-012	MAINTENANCE STEP KIT, RH
		X							D139-799-015	ENGINE WASH KIT
			X						D139-799-017	CARGO FLOOR PROTECTOR KIT
				X					D139-799-019	CABIN FLOOR PROTECTOR KIT
					X				D139-799-112	MAINTENANCE STEP WITH GRAB BAR KIT, RH
						X			D139-799-211	QUICK RELEASE MAINTENANCE STEP KIT, LH
							X		D139-799-212	QUICK RELEASE MAINTENANCE STEP KIT, RH
								X	D139-799-213	QUICK RELEASE MAINTENANCE STEP PROVISIONS KIT
			2						D3580-1	JOGGLE BRACKET
			2	8					D3628-1	CUPPED WASHER
1									D4092-041	MAINTENANCE STEP ASSEMBLY
	1								D4092-042	MAINTENANCE STEP ASSEMBLY
		2							D4121-1	HOSE ASSEMBLY
		1							D4121-3	HOSE ASSEMBLY
		1							D4121-5	HOSE ASSEMBLY
				1					D4130-1	FWD CABIN FLOOR PROTECTOR
				1					D4130-3	AFT CABIN FLOOR PROTECTOR
			1						D4130-5	FWD CARGO FLOOR PROTECTOR
			1						D4130-7	CENTER CARGO FLOOR PROTECTOR
			1						D4130-9	AFT CARGO FLOOR PROTECTOR
		1							D4131-041	MANIFOLD ASSEMBLY
		1							D4131-043	DOUBLER ASSEMBLY
		2							D4146-1	FITTING
			1						D4153-1	JOGGLE BRACKET
			1						D4153-3	JOGGLE BRACKET
				4					D4153-5	CLAMP PLATE
			2						D4166-1	PLACARD, MAX LOAD
		2							D4182-1	FITTING, QUICK DISCONNECT
		1							D4384-1	PLACARD
					1				D4526-042	MAINTENANCE STEP ASSEMBLY, RH
						1			D5238-041	MAINTENANCE STEP ASSEMBLY
							1		D5238-042	MAINTENANCE STEP ASSEMBLY
						1	1	1	D5238-043	LOWER BRACKET, AFT
						1	1	1	D5238-045	LOWER BRACKET, FWD
						1	1	1	D5245-1	MOUNTING BOLT
2	2				2	2	2	2	AN6H12A	BOLT
2	2				2	1	1	1	AN6H13A	BOLT
		4							AN526-1032R16	SCREW
		2							AN832-6J	UNION
		4							AN924-6J	NUT
		20							MS21919WDG09	CLAMP
6	6				6	5	5	5	NAS1149D0663J	WASHER (or AN960JD616)
		4							NAS1149C0932R	WASHER (or AN960C916L)